

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000080**Date Inspected:** 08-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

**Witness:**      **Procedure Qualification Record**  
**Welding**                      **NDT**

**Welder Qualification**  
**Mechanical Testing, describe:**

**Fracture Critical****Index Lot #:** B60-029-06A**Witness Lot #:** B60-005-07**Bridge No:** 34-0006**Component:** N/A**Welder:** Zhang Xing Jin**ID #:** N/A**Joint Description:** B-U2-S

N/A

**WPS ID #:** PWPS-B-T-3221-F

N/A

**Base Metal:** HPS-485W

N/A

**PQR ID #:** HP2006130

N/A

**Thickness:** 75mm

N/A

**Process:** SAW

N/A

**Electrode Spec/Class:** A5.23 / F9A-ENi5 H2

N/A

**Positions:** 1G

N/A

**Backing Material:** HPS-485W

N/A

**CWI:** Huang Wei

N/A

**Average Amps:**

N/A

**AWS Code:** AWS D1.5 (2002)

N/A

**Average Volts:**

N/A

**Applicable Sec:** 5.13

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector witnessed mechanical testing of a Procedure Qualification (PQR) test plate using Submerged Arc Welding (SAW), Lincoln LA-85 with MIL800-HPNi Flux, in the 1G (flat) position. One side bend test failed to meet the contract requirements. All other mechanical tests appeared to comply with the contract documents.

**Summary of Conversations:**

ZPMC informed QA that they would prepare two additional side bend samples for retest.

**Observed welding,testing or results:**

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

---

## WELDING WITNESS REPORT

( Continued Page 2 of 2 )

---

---

**Inspected By:** McClary,David

Quality Assurance Inspector

---

**Reviewed By:** Lowry,Patrick

QA Reviewer